



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.0112
Job Sheet 170484



Part No: 647.0112

Job Qty: 24 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	2/7/18	2/7/18	0.00	0.00	Start Up Waterjet		SC 18/02/04
100	Waterjet	24 pcs	2/7/18	2/7/18	0.00	0.94	Waterjet1		SC 18/02/04
110	QC	24 pcs	2/7/18	2/7/18	0.00	0.00	QC2 Waterjet-1		SC 18/02/04
120	QC	24 pcs	2/7/18	2/7/18	0.00	0.00	QC8-1		SC 18/02/04
130	Brake NC	24 pcs	2/7/18	2/7/18	0.00	1.07	Brake NC 1		FF 1 30
140	QC	24 pcs	2/7/18	2/7/18	0.00	0.00	QC5		SC 18/02/04
150	SprayPaint	24 pcs	2/8/18	2/8/18	0.00	0.56	Spray Paint		SC 18/02/04
160	QC	24 pcs	2/8/18	2/8/18	0.00	0.00	QC14		SC 18/02/04
170	Packaging	24 pcs	2/8/18	2/8/18	0.00	0.00	Packaging3-1		SC 18/02/04
180	QC21-SA	24 Ea	2/8/18	2/8/18	0.00	0.00	QC21		SC 18/02/04

Part Op 100 - 1-Cut as per Dwg

Descriptions: 130 - USE DT9834 FOR FORMING

150 - PRIME AS PER DWG NOTE 6 BATCH: 138791

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S14GA	1	64	0	0

5021856

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐												
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																												
Description Work Order Deviation		Disposition		Completed By																												
Change No: Operation: Revision: Original Serial #: S038809 PART NO: 647.0112 Start up Operation 02/04/18 Job No: 170484 Strut Bracket S038809 DART AEROSPACE				Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																												
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com <table style="width:100%; border: none;"> <tr> <td style="border: none;"> ☐ Dimensions incomplete/Unclear ☐ Misaligned/off center </td> <td style="border: none;"> ☐ Fit/Function ☐ Turning Sequence </td> </tr> <tr> <td style="border: none;"> ☐ Marks/Chatter ☐ Drill Holes </td> <td style="border: none;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread </td> </tr> </table>			☐ Dimensions incomplete/Unclear ☐ Misaligned/off center	☐ Fit/Function ☐ Turning Sequence	☐ Marks/Chatter ☐ Drill Holes	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread
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OTHER : _____																																

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	0,179	
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190	0,193	
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270	0,302	
4	Strut Bracket	0.900Inches ± 0.030	0.930 0.870	0,901	
5	Strut Bracket	0.350Inches ± 0.010	0.360 0.340	0,352	
6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470	1,499	
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976	1,007	
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070	0,073	

Plex 1/16/18 2:25 PM dart.lacelle.linda

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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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